

24

Date: Wednesday, 5/23/2007 3:18:53 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE RH 206A/B
Job Number	: 32453		
Estimate Number	: 10802		
P.O. Number	:	Part Number	: D206642612
This Issue	: 5/23/2007 S.O. No. :	Drawing Number	: IIN D206-642 REV K
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LANDING GEAR	Drawing Revision	: K
Previous Run	: 31964	Material	:
Written By	:	Due Date	: 6/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.05.24</u>		
Comment	: Est Rev:B 05.10.27 Revised pick list KJ/EC Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM		



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-612 CHG002



KS 07.05.30

2.0	32453A	FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW
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Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B
D206-642-641 B 32453A

AS 08/02/22 (4C)

3.0	D206651041	206 A/B GHW Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
1 D206651041 GHW Kit Batch: 3235

AS 08/02/22 (XU)

4.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: D2652

Qty Part Number Description Batch

16 D266-651-041 GHW Adapter 37301

AS 08/02/19 (X)

5.0	D26652	Bushing Saddle, RH, Fwd, Aft, Out
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2665-2 Saddle 34780 x1 32623 x1

AS 08/02/19 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:18:53 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 32453

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D26662

Saddle, RH, Fwd, Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2666-2 Saddle

34781

AS

08/02/19

(XV)

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

34628

AS

08/02/19

(XV)

8.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer

345497

AS

08/02/19

(XV)

9.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer

34782

AS

08/02/19

(XV)

10.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer

340336

AS

08/02/19

(XV)

11.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 AN3C36A Bolt

M106541

AS

08/02/19

(XV)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:18:53 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 32453

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN3C41A Bolt

M106169 x4 106176 x4

AS 08/02/19 (X)

13.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt

M105793 x7 M106519 x5

AS 08/02/19 (X)

14.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt

106552

AS 08/02/19 (X)

15.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C13A Bolt

M106516

AS 08/02/19 (X)

16.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt

M105746

AS 08/02/19 (X)

17.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batc

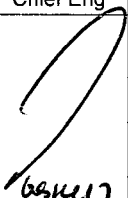
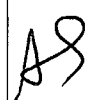
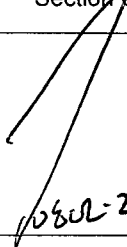


M18918

AS 08/02/19 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206 642-612 PAR #: N/A Fault Category: Prod/Packaging NCR: (Yes) No DQA: 1 Date: 08/02/06
 QA: N/C Closed: 1 Date: 08/02/06

NCR: <u>32453</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0801-25	1.0	2 bolts missing from kit R.C: Human error		Add Qty 2 AN5-332 AN5C-32A M 05746	 08/02/05	 0801-25		 0801-25

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:18:53 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206AB

Job Number: 32453

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN5C35A Bolt

18.0

AN960C10L

washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 AN960C10L Washer

M107008

AS

08/02/19

(X)

19.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer

M105793

AS

08/02/19

(X)

20.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer

M103344

AS

08/02/19

(X)

21.0

MS210433

Nut



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut

M107214

New Batch

AS

08/02/22

(X)

22.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut

M100763

AS

08/02/19

(X)

23.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

M105430

AS

08/02/19

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:18:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 32453

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 MS21043-5Nut

24.0

NAS1515H3L

WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 NAS1515H3L Washer

MA9565

N/A
* not enough
quant in
computer

ECN1080p u 08-02-25

AS 08/02/19 (XV)

25.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 NAS1515H4L Washer

M105792

N/A
* not in
computer

ECN1080p u 08-02-25

AS 08/02/19 (XV)

26.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 NAS1515H5 Washer

M106541

N/A

ECN1080p u 08-02-25

AS 08/02/19 (XV)

27.0

NAS1515H6L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 NAS1515H6L Washer

101925

N/A

ECN1080p u 08-02-25

AS 08/02/19 (XV)

28.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batc

4 AN5C7A Bolt

M19185

AS 08/02/19 (XV)

29.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batc

M106662

AS 08/02/19 (XV)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:18:54 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206AB

Job Number: 32453

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 AN6C44A Bolt

30.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt

19105

Washer

AS 08/02/19

(X)

31.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 ms21043-6 Nut

103693

AS 08/02/19

(X)

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-612

Location:

PPP Rev:

8/2/25

SD

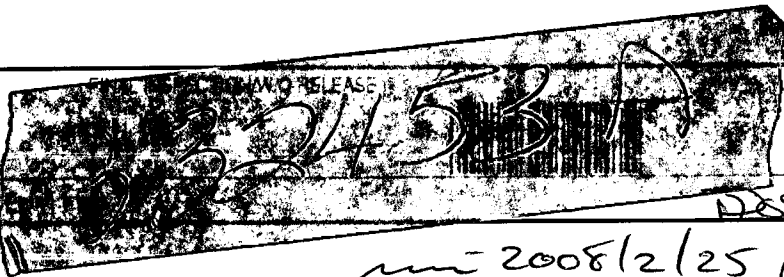
(X)

34.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE



08/02/26

Job Completion



POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

12x D3683-1

B 36319

26 x AN960 C10

B 106302

Add to kit per chg. 003/ECN1080P

26 x MS21250 03004

B 106277

28 x D3672-1

B 34470

24 x D3672-3

B 34471

10 x D3672-5

B 35521

28 x D3672-7

B 35522

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/02/2008 10:05:50 AM

User: Linda Lacelle

Bill of Manufacturing

Part Number : D206642612

Revision : L

Drawing Name : FLOAT SKIDTUBE RH 206A/B

Default Qty. : 1

Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	DC	DOCUMENT CONTROL	0.00	Hours	26.00	0.00
2	D206642641	FLOAT SKIDTUBE HIGH GEAR 206 A/B	1.00	Each	0.00	0.00
▪ 1	DC	DOCUMENT CONTROL	0.00	Hours	26.00	0.00
▪ 2	D2620	Pick:	1.00	Each	35.53	35.53
▪ 3	D2647	Pick:	1.00	Each	2.07	2.07
▪ 4	D32861	Pick:	2.00	Each	7.00	14.00
▪ 5	LANDING GEAR 1	LANDING GEAR RESOURCE 1	0.00	Hours	76.00	0.00
▪ 6	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	26.00	0.00
▪ 7	HAND FINISHING1	HAND FINISHING RESOURCE #1	0.00	Hours	90.00	0.00
▪ 8	QC3	INSPECT POWDER COAT/CHEMICAL	0.00	Hours	26.00	0.00
▪ 9	CR3212404	Pick:	52.00	Each	0.46	23.92
▪ 10	D3289041	Pick:	1.00	Each	0.00	0.00
▪ 11	LANDING GEAR 1	LANDING GEAR RESOURCE 1	0.00	Hours	76.00	0.00
▪ 12	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	26.00	0.00
▪ 13	BENDING	BENDING MACHINE	0.00	Hours	76.00	0.00
▪ 14	LANDING GEAR 1	LANDING GEAR RESOURCE 1	0.00	Hours	76.00	0.00
▪ 15	D2649	Pick:	9.00	Each	0.62	5.58
▪ 16	D32751	Pick:	6.00	Each	1.40	8.40
▪ 17	D32863	Pick:	2.00	Each	2.31	4.62
▪ 18	LANDING GEAR 1	LANDING GEAR RESOURCE 1	0.00	Hours	76.00	0.00
▪ 19	QC9	VISUAL WELDING INSPECTION	0.00	Hours	26.00	0.00
▪ 20	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	26.00	0.00
▪ 21	HAND FINISHING1	HAND FINISHING RESOURCE #1	0.00	Hours	37.00	0.00
▪ 22	POWDER COATING	POWDER COATING	0.00	Hours	90.00	0.00
▪ 23	QC3	INSPECT POWDER COAT/CHEMICAL	0.00	Hours	26.00	0.00
▪ 24	D3415041	Pick:	1.00	Each	9.96	9.96
▪ 25	CCR264SS33	Pick:	2.00	Each	0.14	0.28
▪ 26	CR3212403	Pick:	2.00	Each	0.51	1.02
▪ 27	ALS71032130	Insert	64.00	Each	0.12	8.00
▪ 28	HAND FINISHING1	HAND FINISHING RESOURCE #1	0.00	Hours	37.00	0.00
▪ 29	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	43.00	0.00
▪ 30	D353515	WEARSHOE	1.00	Each	0.00	0.00
▪ 31	D353521	WEARSHOE	1.00	Each	0.00	0.00
▪ 32	D353535	WEARSHOE	1.00	Each	0.00	0.00
▪ 33	D353541	WEARSHOE	1.00	Each	0.00	0.00
▪ 34	D353615	GASKET	1.00	Each	0.00	0.00
▪ 35	D353621	GASKET	1.00	Each	0.00	0.00
▪ 36	D353635	GASKET	1.00	Each	0.00	0.00
▪ 37	D353641	GASKET	1.00	Each	0.00	0.00
▪ 38	D35371	WEARPAD	7.00	Each	0.00	0.00
▪ 39	D35373	WEARPAD	1.00	Each	0.00	0.00
▪ 40	AN3C4A	BOLT	66.00	Each	0.28	18.56
▪ 41	NAS1515H3L	Washer	2.00	Each	0.08	0.17
▪ 42	AN960C10L	Pick:	78.00	Each	0.03	2.34
▪ 43	D36831	INSERT	12.00	Each	0.00	0.00

Date: Monday, 25/02/2008 10:05:50 AM

User: Linda Lacelle

Bill of Manufacturing

Part Number		: D206642612		Revision		: L	
Drawing Name		: FLOAT SKIDTUBE RH 206A/B		Default Qty.		: 1	
Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost	
44	D34131	Pick:	1.00	Each	21.26	21.26	
45	AN4C5A	Pick:	1.00	Each	1.02	1.02	
46	AN960C416	washer	1.00	Each	0.02	0.02	
47	D2646	Pick:	1.00	Each	9.84	9.84	
48	MS27039C105	SCREW	12.00	Each	0.30	3.61	
49	HAND FINISHING1	HAND FINISHING RESOURCE #1	0.00	Hours	90.00	0.00	
50	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	26.00	0.00	
51	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00	
52	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00	
3	D206651041	1 D206651041 GHW Kit	1.00	Each	13.16	13.16	
4	D26652	Pick: ✓	2.00	Each	96.09	192.19	
5	D26662	Pick: ✓	2.00	Each	73.83	147.66	
6	D2652	Pick: ✓	16.00	Each	0.68	10.88	
7	D2712	Pick: ✓	10.00	Each	0.10	1.00	
8	D2884	Pick: ✓	2.00	Each	1.19	2.38	
9	D2885	Pick: ✓	2.00	Each	0.34	0.68	
10	D33963	Pick: ✓	2.00	Each	1.21	2.42	
11	AN3C36A	Pick: ✓	6.00	Each	2.37	14.22	
12	MS21250 03004	HIGH STEEL BOLT	6.00	Each	1.49	8.96	
13	D36721	PHENOLIC WASHER	18.00	Each	0.26	4.85	
14	AN4C6A ✓	Pick: ✓	12.00	Each	0.57	6.84	
15	AN5C7A	Pick: ✓	4.00	Each	0.00	0.00	
16	AN5C11A	Pick: ✓	4.00	Each	2.10	8.40	
17	AN5C32A	Pick: ✓	4.00	Each	6.12	24.48	
18	AN5C35A	Pick: ✓	1.00	Each	4.74	4.74	
19	AN5C13A	bolt ✓	1.00	Each	2.95	2.95	
20	AN6C44A	Pick: ✓	2.00	Each	0.00	0.00	
21	AN3C41A	BOLT ✓	8.00	Each	8.85	70.84	
22	AN960C10L	Pick: ✓	30.00	Each	0.03	0.90	
23	AN960C416L	Pick: ✓	24.00	Each	0.03	0.72	
24	AN960C516L	Pick: ✓	8.00	Each	0.12	0.96	
25	AN960C616	Pick: ✓	4.00	Each	0.00	0.00	
26	MS210433	Pick: ✓	17.00	Each	0.23	3.91	
27	MS210434	Pick: ✓	12.00	Each	0.33	3.96	
28	MS210435	Pick: ✓	4.00	Each	0.82	3.28	
29	MS210436	Pick: ✓	2.00	Each	0.00	0.00	
30	AN960JD10	Washer ?	6.00	Each	0.04	0.28	
31	D36831	INSERT	12.00	Each	0.00	0.00	
32	D36727	PHENOLIC WASHER	8.00	Each	0.26	2.15	
33	D36725	PHENOLIC WASHER	16.00	Each	0.33	5.29	
34	D36723	PHENOLIC WASHER	24.00	Each	0.27	6.49	
35	MS27039C105	SCREW	12.00	Each	0.00	0.00	
36	QC4	INSPECT 100% KITS FOR COMPLETENESS	0.00	Hours	26.00	0.00	
37	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00	

Date: Monday, 25/02/2008 10:05:50 AM

User: Linda Lacelle

Bill of Manufacturing

Part Number : D206642612

Revision : L

Drawing Name : FLOAT SKIDTUBE RH 206A/B

Default Qty. : 1

Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
38	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
Total BOM Cost						714.88

Date: Wednesday, 5/23/2007 3:19:55 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32453A
Estimate Number : 10803
P.O. Number :
This Issue : 5/23/2007 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : LANDING GEAR
Previous Run : 32452A
Written By :
Checked & Approved By :
Comment : Est Rev:B 05.11.15 Added washers for aft cap, wearshoes and ring EC
Est Rev:C 06-05-31 Revised steps JLM
Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM

Drawing Name : FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER
Part Number : D206642641
Drawing Number : D3288 BEVC
Project Number : N/A
Drawing Revision : F Rev F
Material :
Due Date : 6/15/2007 Qty: 1 Um: Each

6/12 24
02.05.24

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-641 CHG002

N/A

2.0

D2620

Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 3" OD Bent Tube

B33829

DP

7-8-15

3.0

D2647

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap

B29328 BE7-8-16

4.0

D32861

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler

B32514

DP

7-8-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:19:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32453A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube, grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288. Grind to obtain proper fit

A/R AL ROD

Batch:

~~829320~~
M104967/M104221

4-Grind welds flush to cap on top surface only.

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9-Insert D3286-1 doubler using DT8732 & DT8879, then locating doubler off the D3286-1 doubler, leave Dt8732 for added support

3/16" holes cleco

10-Drill D3286-1 doubler rivet holes in tube using #40 drill, spot drilling doubler at the same time.

11-Working from center out, drill #30 holes into D3286-1 Doubler. cleco each hole after its drilled, Verify angle of holes to accomodate rivet heads.

12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.

13-Remove D3286-1 doubler, identify orientation, deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

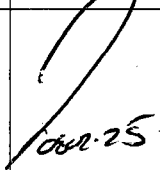
6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.12.10	5.	PER DWG D3288 Rev F, MSD FLOAT BAGS ARE NOW INSTALLED 17° BE INBOARD. DRILL MID-SECTION PER DWG D3288 Rev F SEE SECTION J-J	PH	07.12.10	1	PH per QSI 042 07.12.10	 06.25	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/06
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-10	5	HOLES ARE MADE PER DWG D3233 REV C - MID FLOAT BAG SECTION	PH per QSI 042 07-12-10	FILL HOLES PER WELD. DRILL HOLES FOR DRILL HOLES AND INITIAL INSERTS PER DWG D3233, REV F- SEE SECTION J-5	BE 07-12-11	<i>[Signature]</i> 07/12/12	PH per QSI 042 07-12-10	<i>[Signature]</i> 07/12/12

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:19:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32453A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-12-13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-1-22

9.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

52 CR3212-4-04 Rivet

M-104625-10

M 106277-31

M 106815-14

DP 8-1-22

10.0

D3289041

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3289-041 Float Web

B36187

DP 8-1-22

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Holes to finished size as per DWg D3288. Debur.

W 7-12-13

2-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

DP 8-1-22

3-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

32105462

Sikaflex expire date:

8-1-30

Start:

8-1-23

Time:

3:25

Finish:

06/01/24

Time:

7:55 AM

(Adhere for 12 hours)

W 8-1-23

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 06/01/24 (P)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:19:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32453A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

FL 8-2-1

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Debur

SL 8-2-4

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer

B36013

BE 08/02/04

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D3275-1 Crossbolt spacer

B34619

BE 08/02/04

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer

B35048

BE 08/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:19:55 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32453A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

A/R Aluminum Rod

m 106330 BE 08/02/04

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

A/RSS Rod

NONE BE 08/02/04

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

SLAS

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 08-02-05 ①

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/02/05

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 08/02/06 ①

22.0

POWDER COATING

POWDER COATING




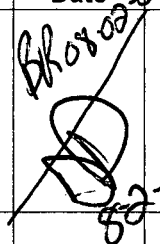
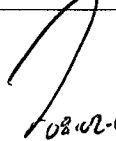


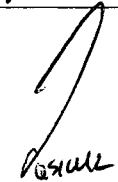

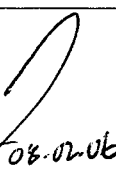
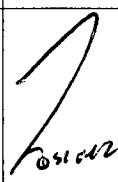
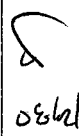
Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 08/02/06 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-641 PAR #: N/A Fault Category: Prod/Landing Gear NCR: Yes No DQA: D Date: 08/02/06
 QA: N/C Closed: A Date: 08/02/06

NCR: 32453A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/06	#22.0	During Paint/powdercoat inspection it was found that the insert holes according to section S-3 on Dwg D3288 were not opened up to the correct dia.		open holes to correct dia and touch up holes with inrow paint	 08-02-06	 08-02-06		 08/02/06
	#14.0	R.C were missed during inspection		Remind QC inspector to be more attentive	 N/A 08-02-06	 08-02-06		 08/02/06

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:19:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32453A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-02-06

①

24.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate

B 33842

BR.

25.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet

M 106825

BR

26.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet

M 15918 (A)

~~M 15918 (B)~~

BR

27.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Insert

Batch:

M 105729

BR

→ TURN OVER

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288, Install with LPS-3

A/R LPS-3 Batch:

M 106096

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291

M 105585

BR 08-02-07

BR 08-02-07

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.12.11	27	<div>Qty 12</div> <div>Install D3683-1 INSERT B <u>3 36319</u></div> <div>Qty 12 MS27039C1-US SCREW B <u>M 106574</u></div> <div>} PER D3217 Rev F</div> <div>SEE SECTION J-J</div>	RA	07.12.11	1	<div>RA</div> <div>07.12.11</div> <div>Per</div> <div>07.12.11</div>	<div></div> <div>0802-06</div>	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:19:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32453A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

Sikaflex expire date:

08-07

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inserts & Nut plate

08/02/07 (X)

30.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B36653

BR

31.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B31991

BR

32.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B36194

BR

33.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B31993

BR

34.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B33964

BR

35.0

D353621

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B31995

BR

BR 08-02-07 D.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:19:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32453A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B36609

37.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B37997

38.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WEARPAD

Batch: B36714

39.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B33285

40.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total : 66.0000 Each(s)

BOLT

Batch: M107008

41.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 NAS1515H3L Washer M106514

42.0

AN960C10L

washer



Comment: Qty.: 64.0000 Each(s)/Unit Total : ~~64.0000~~ Each(s)

Pick:

Qty Part Number Description Batch

RY 07.12.11

73

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:19:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32453A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

78 AN960C10L Washer M/107008

43.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring

B34753

44.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt

M/104930

45.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer

426
M/0546

46.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

B32427

47.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960C10L Washer

pu
0712-11

BR 08-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:19:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32453A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

Sikaflex expire date:

M/105585
68-07

6-Coat all exposed fastners with LPS Procyon, remove any excess on powder coat with MEK Degreasser.

A/R LPS Procyon

Batch:

M/106096

BR 08-02-07

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/08 @

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location:

PPP Rev:

AP

32453

8/2/05

500 (12)

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/06

Job Completion



run 2008/2/25

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

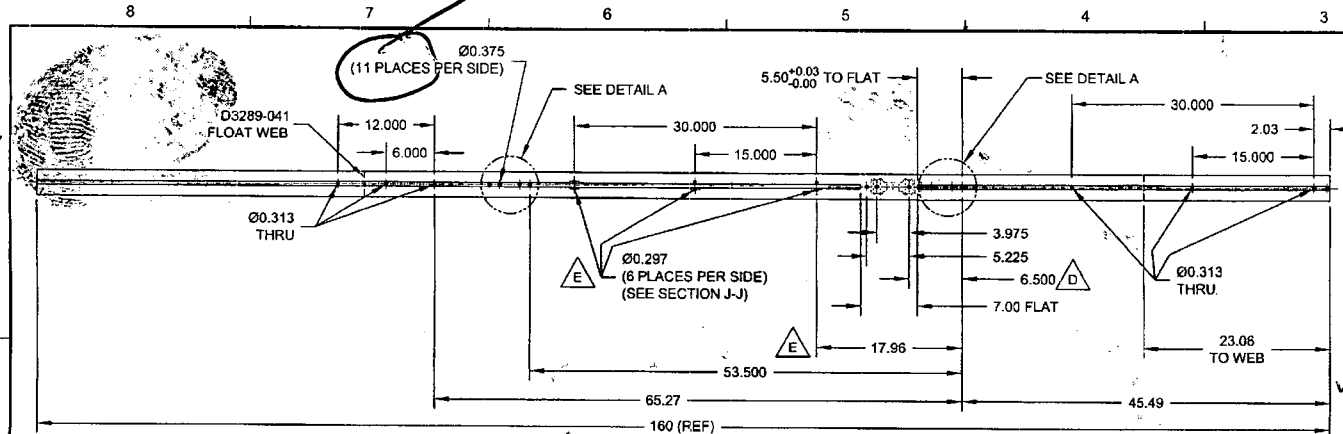
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

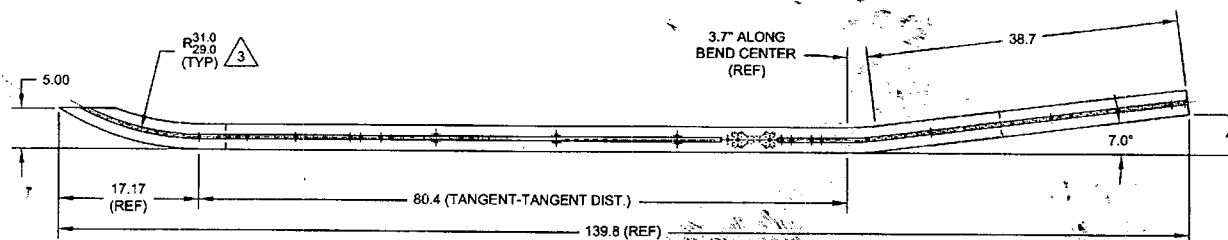
NOTE: Date & initial all entries

PRELIMINARY ISSUE

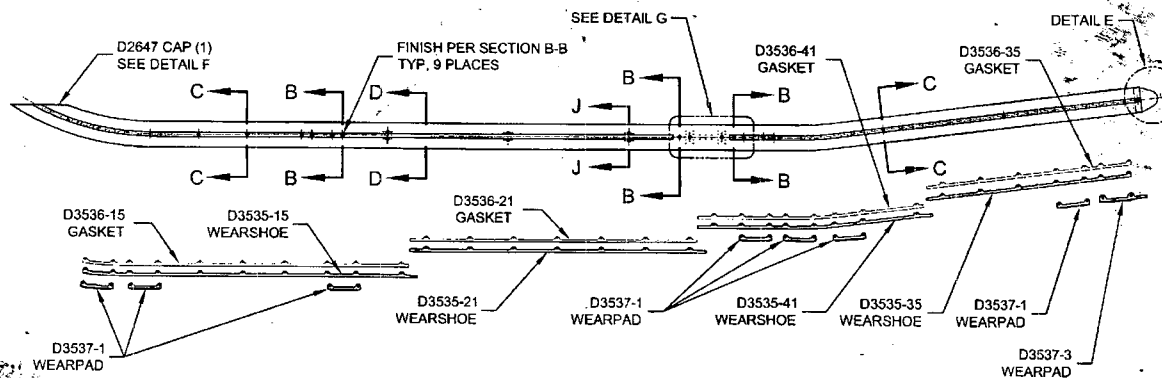
98
2-12-13



D3288-041 DRILLING/WEB ASSEMBLY DETAIL



D3288-041 BENDING DETAIL



D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY

Qty	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALST-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C6A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-403	RIVET
52	CR3212-4-04	RIVET
12	MS27038C-1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- DAMAGE TOLERANCE ON FWD BEND: THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES.
- DRILL 0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
- DRILL 0.297 HOLES FOR ALST-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALST-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- WELDING: PER DART QSI 004.

F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALST-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	07.11.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3288

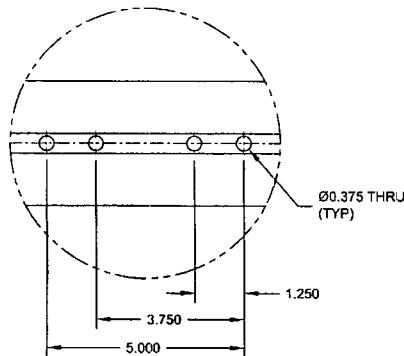
REV. F

SHEET 1 OF 2

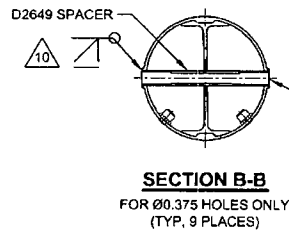
TITLE SKIDTUBE ASSEMBLY

SCALE 1:15

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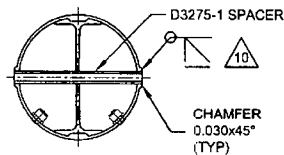


DETAIL A: DRILL DETAIL



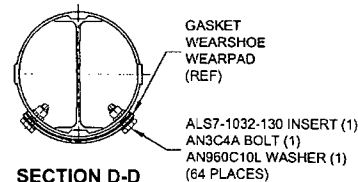
SECTION B-B

FOR Ø0.375 HOLES ONLY
(TYP, 9 PLACES)



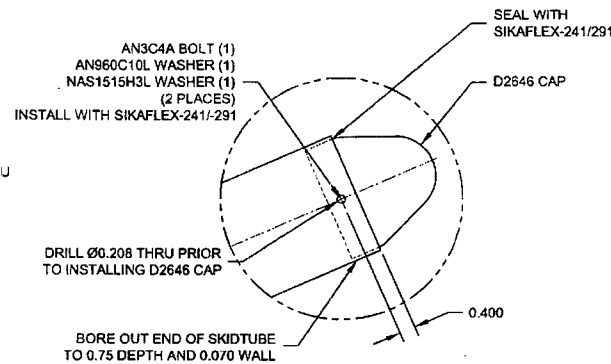
SECTION C-C

FOR Ø0.313 HOLES ONLY
(TYP, 6 PLACES)

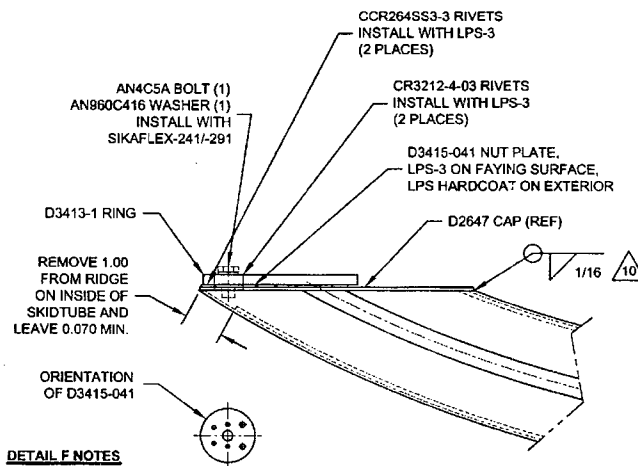


SECTION D-D

FOR WEARSHOES INSTALL ONLY
(TYP, 32 PLACES)



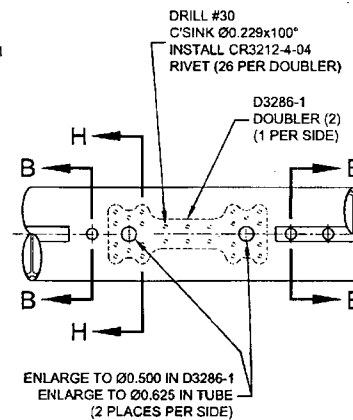
DETAIL E



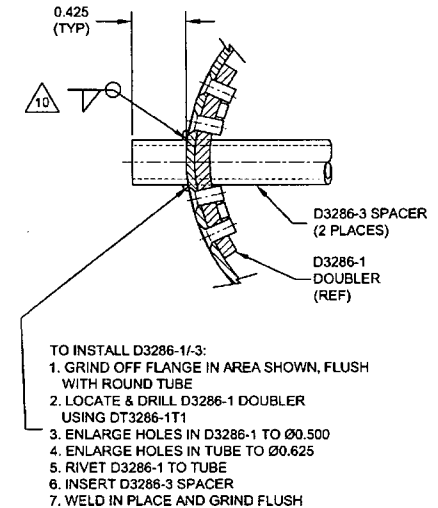
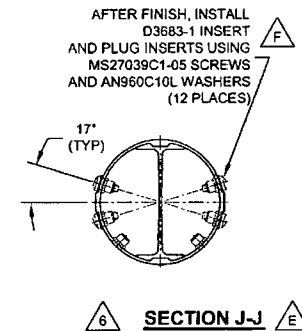
DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL



DETAIL G
SCALE 1:5



SECTION H-H
NOT TO SCALE

DESIGN	90	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EH	DRAWING NO.	REV. F
MFG. APPR.	EA	D3288	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	+	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NO. 157

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name Barclay E
Joint Welding Procedure GTAW
Part number and Job number DACB 612 341 / B36135

TEST WELDS REQUIRED

BASE METAL Aluminum WELDING PROCESS TIG
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 08-01-07 Qualifier Pat. Dural